

Date: Friday, 01/08/2008 10:42:41 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 SADDLE INBOARD, LEFT SIDE		
Job Number	: 40898					
Estimate Number	: 11013					
P.O. Number	:			Part Number	: D26681	
This Issue	: 01/08/2008		S.O. No. :	Drawing Number	: D2668 REV.D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: D	
Previous Run	:			Material	:	
Written By	:			Due Date	: 30/08/2008	
Checked & Approved By	: JUO 08.8.05			Qty:	6	
Comment	: Est: D 02.03.15 Added DEO 9122 NC Est Rev:D As per Rev D 07-03-19 JLM			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 2X6X6.25 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length Batch No: B34201	J.F. 08/09/03 6
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1-Inspect part number and batch number are programmed correctly. 3-Fixturing Inspection last completed on N/A by _____ 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 7- Deburr	J.F. 08/09/03 6
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	J.F. 08/09/03 6
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 08/09/03 6

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 SADDLE INBOARD, LEFT SIDE

Job Number: 40898

Part Number: D26681

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



24 08/09/03

6

Comment: SECOND CHECK

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1



08-09-08 X6

7.0 POWDER COATING POWDER COATING



1108523



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 1:15pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 1:45pm

08-09-10

6

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



6

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



6X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 427

8/9/11

SP

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/09/11

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11 08/09/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 40898	
Description: 206 Saddle, Inboard, Left side				Part Number: D2668-1	
Inspection Dwg: D2668 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2668 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121"	.121"	.120"	.120"		
B	0.100	0.140		.135"	.136"	.126"	.127"		
C	1.125	1.145		1.129"	1.134"	1.139"	1.134"		
D	0.615	0.685		.663"	.663"	.663"	.663"		
E	0.240	0.260		.258"	.251"	.252"	.252"		
F	1.313	1.343		1.323"	1.323"	1.323"	1.323"		
G	0.210	0.220		.221"	.221"	.221"	.221"		
H	0.100	0.180		.140"	.140"	.140"	.140"		
I	2.470	2.510		2.494"	2.494"	2.494"	2.494"		
J	1.565	1.585		1.569"	1.574"	1.574"	1.574"		
K	0.235	0.240		.237"	.237"	.238"	.238"		
L	0.100	0.120		.110"	.110"	.110"	.110"		
M	0.990	1.010		.990"	1.001"	1.001"	1.001"		
N	0.510	0.515		.510"	.510"	.510"	.510"		
O	5.990	6.010		6.002"	6.002"	6.002"	6.002"		
P	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
Q	2.495	2.505		2.502"	2.502"	2.502"	2.502"		
R	0.313	0.318		.314"	.314"	.314"	.314"		
S	0.315	0.322		.320"	.320"	.320"	.320"		
T	1.995	2.005		2.001"	2.001"	2.001"	2.001"		
U	1.357	1.367		1.364"	1.364"	1.364"	1.364"		
V	0.787	0.807		.802"	.802"	.802"	.800"		
W	1.040	1.060		1.047"	1.050"	1.049"	1.048"		
X	1.674	1.684		1.681"	1.681"	1.681"	1.681"		
Y	0.257	0.262		.258"	.258"	.258"	.258"		
Z	0.912	0.932		.922"	.924"	.922"	.921"		
AA	0.490	0.510		.503"	.506"	.501"	.502"		
AB	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J-F.	Audited by:	160
Date:	08/09/03	Date:	08/09/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	SP

DART AEROSPACE LTD				Work Order: 40 898
Description: 206 Saddle, Inboard, Left side				Part Number: D2668-1
Inspection Dwg: D2668 Rev. D				Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2668 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		1.20"	1.20"				
B	0.100	0.140		1.28"	1.27"				
C	1.125	1.145		1.134"	1.134"	3			
D	0.615	0.685		1.663"	1.663"				
E	0.240	0.260		1.252"	1.252"				
F	1.313	1.343		1.323"	1.323"				
G	0.210	0.220		1.221"	1.221"				
H	0.100	0.180		1.140"	1.140"				
I	2.470	2.510		2.494"	2.494"				
J	1.565	1.585		1.574"	1.574"				
K	0.235	0.240		1.237"	1.237"				
L	0.100	0.120		1.110"	1.110"				
M	0.990	1.010		1.003"	1.001"				
N	0.510	0.515		1.510"	1.510"				
O	5.990	6.010		6.002"	6.002"				
P	1.245	1.255		1.250"	1.250"				
Q	2.495	2.505		2.502"	2.502"				
R	0.313	0.318		1.314"	1.314"				
S	0.315	0.322		1.320"	1.320"				
T	1.995	2.005		2.001"	2.001"				
U	1.357	1.367		1.364"	1.364"				
V	0.787	0.807		1.804"	1.801"				
W	1.040	1.060		1.050"	1.048"				
X	1.674	1.684		1.681"	1.681"				
Y	0.257	0.262		1.258"	1.258"				
Z	0.912	0.932		1.920"	1.923"				
AA	0.490	0.510		1.505"	1.504"				
AB	0.178	0.198		1.188"	1.188"				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F.	Audited by:	RF
Date:	08/09/03	Date:	08/09/03

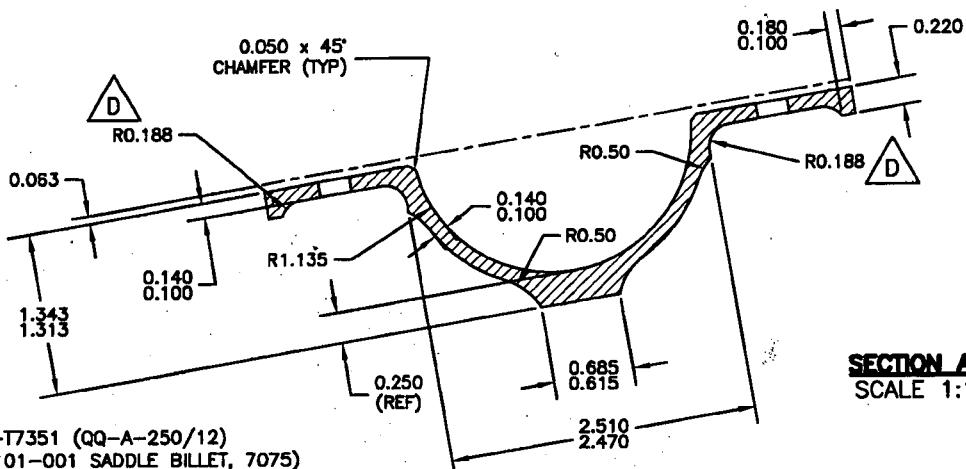
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2668 REV. D SHEET 1 OF 1
DATE		TITLE SCALE
06.11.08		SADDLE AFT INSIDE HIGH 1:3
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313

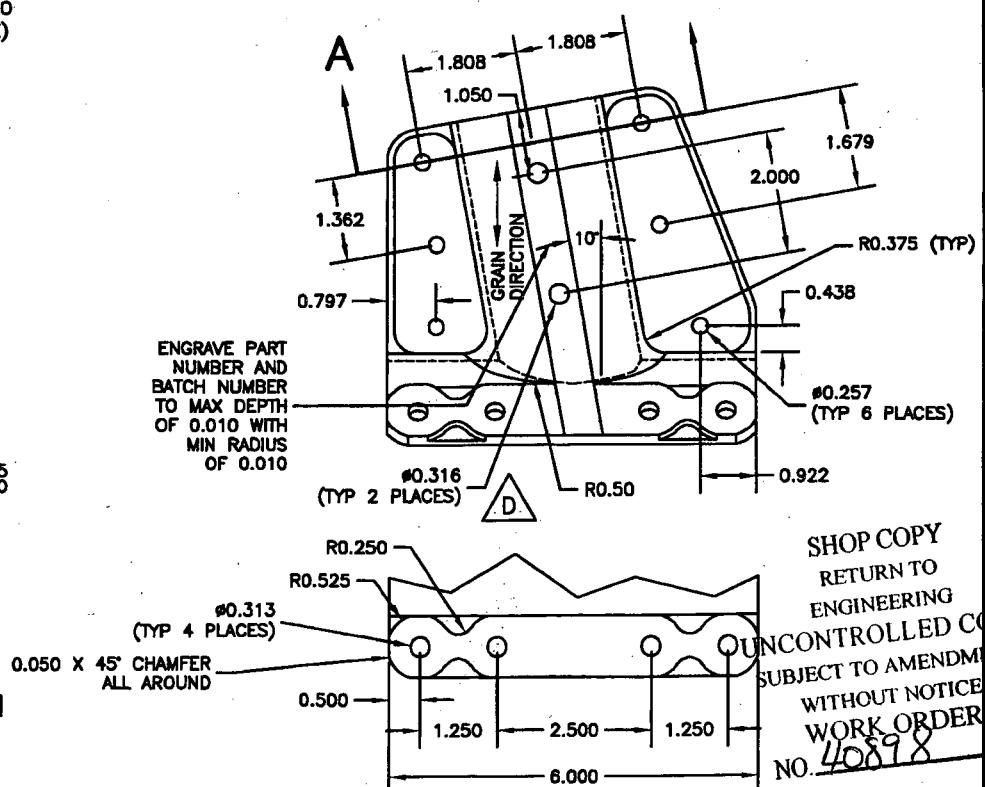
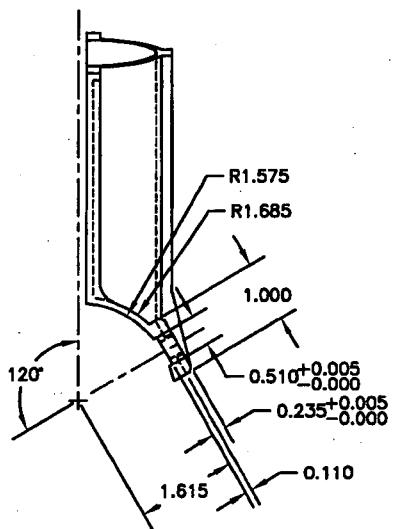
RELEASED

07.02.12



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2668-1 SHOWN (D2668-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2668-1 SADDLE AFT INSIDE HIGH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40898

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.